

Work Order ID 159732 -2

Monday, May 01, 2017 10:16:58 AM

159732

Page 1

Item ID: D3934-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clip Assembly

Start Date: 4/20/2017 Start Qty: 38.00

38

Cust Item ID:

Required Date: 4/25/2017 Req'd Qty: 38.00

38

Customer:

Reference: SCHEDULED/S

Approvals: Process Plan:

Date: MAY 01 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3934

RevA

100

0.03

100

Waterjet

Memo

0.69

FLOW CNC Waterjet

1-Cut as per Dwg D3934

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.38

Quality Control

38

05/01/17

38

05/01/17

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Item ID: D3934-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clip Assembly
 Start Date: 4/20/2017 Start Qty: 38.00 ***38*** Cust Item ID:
 Required Date: 4/25/2017 Req'd Qty: 38.00 ***38*** Customer:
 Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.76				<u>38</u>			DAS 38 9-88 MAY 02 2017
130 *130* Brake NC Brake NC	Memo 1- C'sink holes as per dwg 2- Bend as per dwg D3934	0.14 0.80			DAS 30 9-88	<u>38</u>			MAY 02 2017 DAS 36 9-88
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.76				<u>38</u>			DAS 38 9-88 MAY 02 2017

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Stop ***NR2***

Packaging

17/05/07

5

MAY 09 2017



MAY 09 2017



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Item ID: D3934-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clip Assembly
Start Date: 4/20/2017 Start Qty: 38.00 ***38*** Cust Item ID:
Required Date: 4/25/2017 Req'd Qty: 38.00 ***38*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	3.80							
Quality Control									

DAS
21
9-99

MAY 09 2017

Picklist Print

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Page 1

Work Order ID: 159732

159732

Parent Item: D3934-041

D3934-041

Parent Item Name: Clip Assembly

Start Date: 4/20/2017

Required Date: 4/25/2017

Start Qty: 38.00

Required Qty: 38.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA		Purchased	No			150	sf	148.6300	0.021	0.84			
-----------	--	-----------	----	--	--	-----	----	----------	-------	------	--	--	--

M304S20GA

304/316 .040 Sheet

05/17/01

Location

Loc Qty

Loc Code

MAT020

148.63

m136327

3.85

m136568

5.78

m137041

11

m137263

64

m137362

64

0.7

MS21075L3	MS21075L3N	Purchased	No			150	Each	37.0000	1	38			
-----------	------------	-----------	----	--	--	-----	------	---------	---	----	--	--	--

MS21075L3

Nut Plate

17/05/09 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

1

m135774

1

ST298

36

m135908

36

33

M137464
5x

Picklist Print

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Work Order ID: 159732

Parent Item: D3934-041

Parent Item Name: Clip Assembly

159732

D3934-041

Start Date: 4/20/2017

Required Date: 4/25/2017

Start Qty: 38.00

Required Qty: 38.00

MS20426AD3-3

Purchased

No

100

Each

3,333.000

2

76

MS20426AD3-3

RIVET

12/05/09 **DAS**
36
9-89

Location

Loc Qty

Loc Code

FG107/108

160

M137350

160

fg108

200

M134946

200

GA

860

M135274

860

ST312

2113

M135274

2113

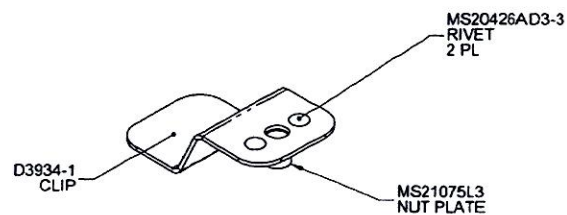
10

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Shop Packet Print

Page 2

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-3	RIVET



D3934-041 CLIP ASSEMBLY

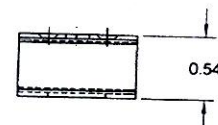
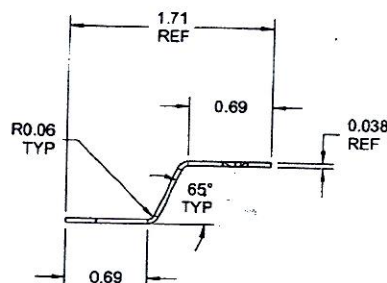
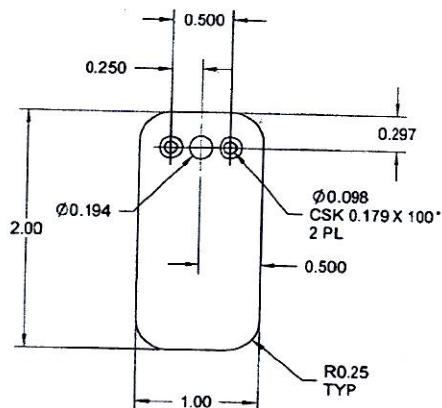
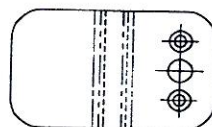
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159732 M.C.
Hose

RELEASED
09/05/05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	PH	09.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3934	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CLIP ASSEMBLY	NTS
DATE	09.04.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3934-1F FLAT PATTERN

D3934-1 CLIP
(MAKE FROM D3934-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
09/05/15

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	JE	DRAWING NO. D3934	REV. A
MFG. APPR.	JE	SHEET 2 OF 2	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CLIP ASSEMBLY	NTS
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